

611

Date: Friday, 1/25/2008 10:38:04 AM
User: Kim Johnston

Process Sheet

Customer : *CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE HIGH GEAR 206 A/B
Job Number : 36952A
Estimate Number : 10803
P.O. Number :
This Issue : 1/25/2008 S.O. No. :
Prsht Rev. : NC Part Number : D206642641
First Issue : 1/1 Type : LANDING GEAR Drawing Number : D3288 REV F U/R
Previous Run : 36951A Drawing Revision : F
Written By : Due Date : 3/10/2008 Qty: 1 Um: Each
Checked & Approved By :
Comment : Est Rev:B 05-11-15 Added washers for aft cap, wearshoes and ring EC
Est Rev:C 06-05-31 Revised steps JLM
Est Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM
Est Rev:E 07-12-06 ECN 1080p DD verified by:

"UNDER REVIEW"

SCRAP

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-641 CHG003

N/A

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 3" OD Bent Tube B 32449

Job 8-4-1

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap B 35475 BE 08-04-01

4.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler B 33895

2 8-4-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr FWD edge of tube, grind bending marks.

2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.

3-Weld Fwd Cap as per Dwg D3288, Grind to obtain proper fit

A/R AL ROD

Batch:

m106330 / m106762 SE 8-04-01

4-Grind welds flush to cap on top surface only.

5-Cut Aft end as per Dwg D3288 from front of tube then deburr

6-Remove inner indexing ridge on aft end as per Dwg d3288

7-Open holes for aft cap as per Dwg D3288 using Dt8025

8-Drill pilot holes using DT8818

9. Open float holes (6 per side) to 0.297 and aft cap holes to 0.208

10-Insert D3286-1 doubler using DT8732 & DT8879, then locating doubler off the

3/16" holes cleco

D3286-1 doubler, leave Dt8732 for added support

~~10-Drill D3286-1 doubler rivet holes in tube using #40 drill, spot drilling doubler at the same time.~~

11-Working from center out, drill #30 holes into D3286-1 Doubler. cleco each hole after its drilled, Verify angle of holes to accomodate rivet heads.

Install 8732 to hold doubler then remove

cleco doubler

~~12-Remove 3/16" clecos only and open GHW holes to .500" as per Dwg D3288.~~

with #30 clecos remove 8732 then open GHW to 0.500"

13-Remove D3286-1 doubler, identify orientation, deburr then attach to W/O

14-Remove indexing edge as per Dwg D3288.

15-C'sink rivet holes as per Dwg D3288.

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(0264122)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

/ 7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H 8-4-22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 8-4-22

9.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number

Description Batch

52 CR3212-4-04

Rivet

M107478

52

H

8-4-22

10.0

D3289041

Float Web (206A/B)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3289-041 Float Web

B37344

1

H

8-4-22

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Holes to finished size as per DWg D3288.Deburr.

2-Locate, install and rivet doublers as per Dwg D3288. Micro-shave rivets as required.

3-Bond web in place as per Dwg D3288 & QSI 015.

A/R Sikaflex-291

M107809

Sikaflex expire date:

8-10-1

Start: 8-4-22

Time: 1:15pm

Finish: 8/4/23

Time: 8:30am

(Adhere for 12 hours)

H

8-4-22

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/01/23 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

BENDING

BENDING MACHINE



P70

Comment: BENDING MACHINE

Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid)

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

2-C'sink X-bolt holes.

3-Debur and remove a lodine as required for welding.

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D2649 Crossbolt spacer

16.0

D32751

Crossbolt Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 D3275-1 Crossbolt spacer

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

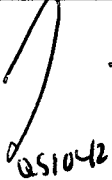

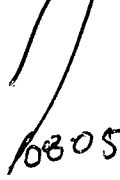
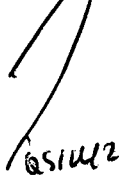

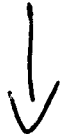


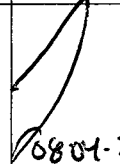
Pick:

Qty Part Number Description Batch

2 D3286-3 Spacer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 1206 642-41 PAR #: N/A Fault Category: Prod / Skidube NCR: (Yes) No DQA: D Date: 08/04/30
QA: N/C Closed: D Date: 08/04/30

NCR: 36952A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-04-30	13.0	Tube is scrap. During bending, a pop was heard from the tube, resulting in 1 rivet head breaking off of the inner doubler on the web.	 Q51042	- Scrap: destroy tube. - 1 rivet at the aft/upper corner popped off. It was noticed that after bending, where the rivet head came off, the holes were slightly mis aligned, after bending, causing the rivet to shear off.	 8-4-30	 080502	 Q51042	 0804-30
								 0804-30

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Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36952A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod.
A/R Aluminum Rod _____

2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required
A/RSS Rod _____

~~3-Grind welds flush to Fwd cap on top surface only.~~

4-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube

5-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.

DTU

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

23.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

WIO: 36952A

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.04.25	18	C'BORE, AT LOCATION INDICATED ON ATTACHED DWG DOES NOT NEED TO BE PERFORMED TH PERMANENT CHANGE	PH	08.04.25	1	PH PER QSS 042 08.04.25	

Part No: D206-642-641 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36952A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate _____

25.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet _____

26.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet _____

27.0

ALS71032130

Insert



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Insert

Batch: _____

28.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D3415-041 Nut Plate as per Dwg D3288 ,Install with LPS-3

A/R LPS-3 Batch: _____

2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes

A/R Sikaflex-291 _____

Sikaflex expire date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36952A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inserts & Nut plate

30.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: _____

31.0

D353521

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: _____

32.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: _____

33.0

D353541

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: _____

34.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: _____

35.0

D353621

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 36952A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: _____

37.0

D353641

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: _____

38.0

D35371

WEARPAD



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

WEARPAD

Batch: _____

39.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: _____

40.0

AN3C4A

BOLT



Comment: Qty.: 66.0000 Each(s)/Unit Total : 66.0000 Each(s)

BOLT

Batch: _____

41.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch _____

42.0

AN960C10L

washer



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 AN960C10L Washer _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 36952A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

batch: _____

44.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring _____

45.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt _____

46.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

washer

batch: _____

47.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap _____

48.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

SCREW

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 36952A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

49.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearshoes/wearpads & Gaskets as per Dwg D3288.

3-Install Ring on Nut Plate as per detail F & Dwg D3288.

4-Spray inside tube with LPS-3 on both sides of web

5-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 _____

Sikaflex expire date: _____

6-Coat all exposed fastners with LPS Procyon,remove any exess on powder coat
with MEK Degreasser.

A/R LPS Procyon Batch:_____

50.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

51.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-641

Location:_____

PPP Rev:_____

52.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-01

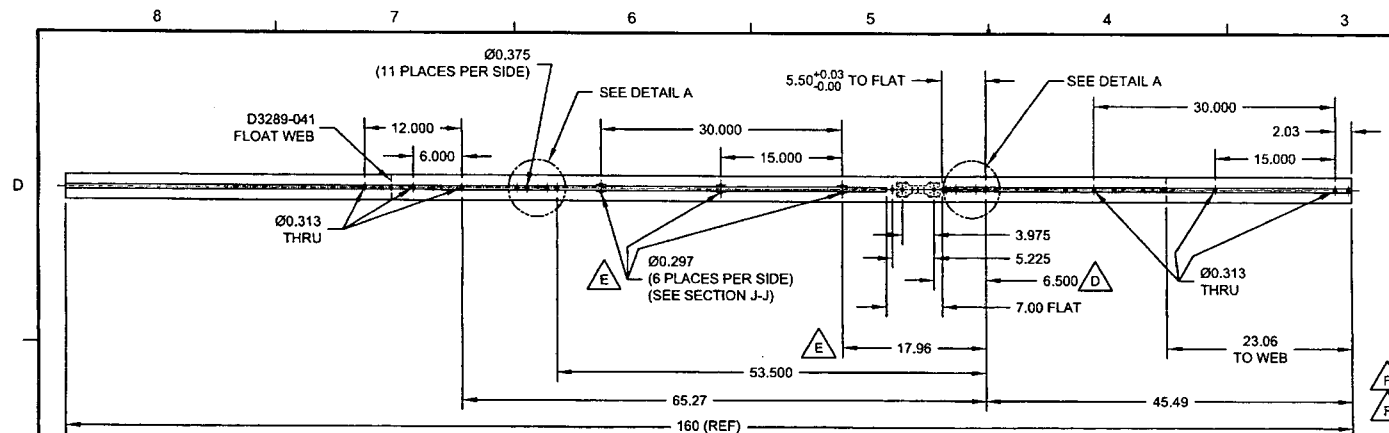
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

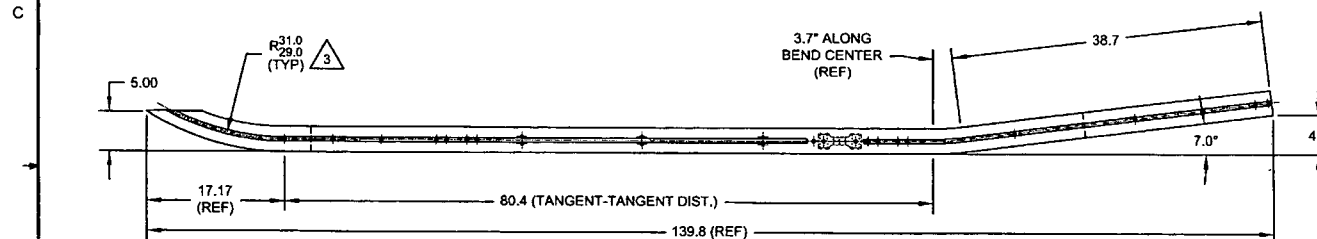
QA: N/C Closed: _____ Date: _____

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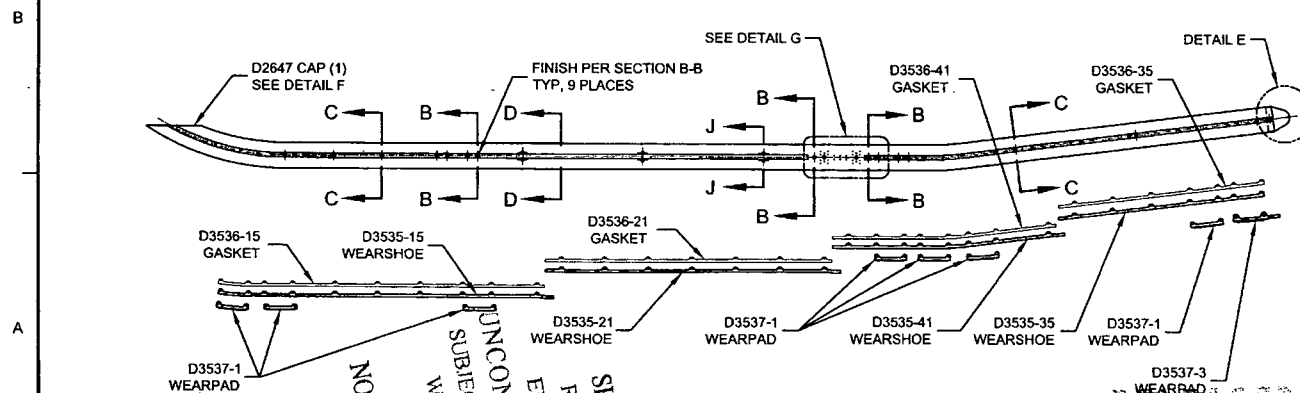
NOTE: Date & initial all entries



D3288-041 DRILLING/WEB ASSEMBLY DETAIL



D3288-041 BENDING DETAIL



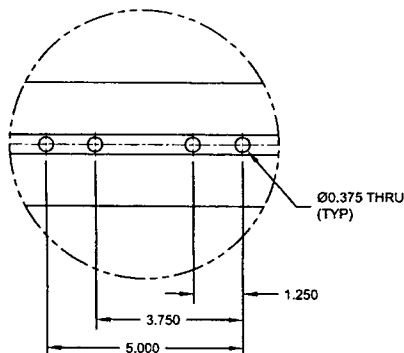
D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY

Qty	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
84	ALST-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN60CA18	WASHER
78	AN60C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

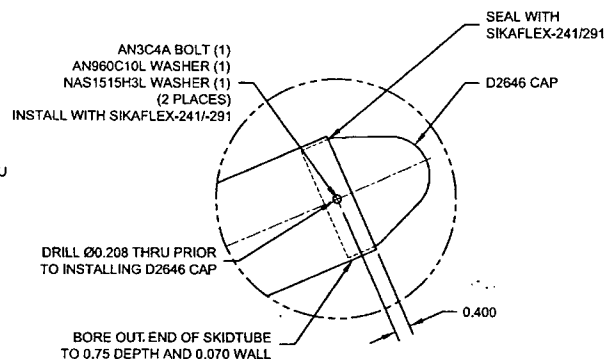
GENERAL NOTES:

1. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
2. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
3. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
4. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. ALL HOLES DRILLED ON CENTERLINES.
6. DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH.
7. DRILL Ø0.297 HOLES FOR ALST-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALST-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291.
8. TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED.
9. UNITS: INCHES UNLESS OTHERWISE NOTED.
10. WELDING: PER DART QSI 004.

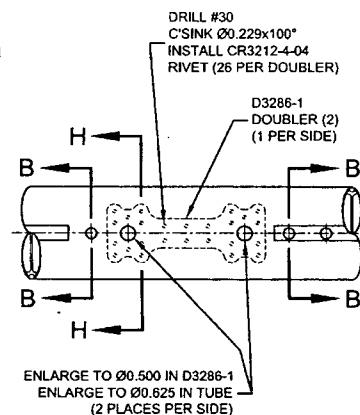
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALST7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS. SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	90		
DRAWN	DL		
CHECKED	PL		
MFG. APPR.	RE		
APPROVED	UP		
DE APPR.			
DATE	07.11.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3288 TITLE SKIDTUBE ASSEMBLY SCALE 1:15 REV. F SHEET 1 OF 2 COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



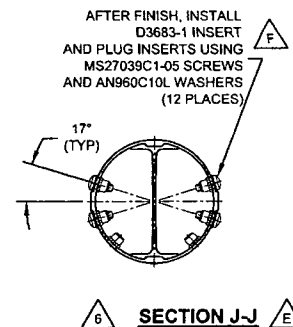
DETAIL A: DRILL DETAIL



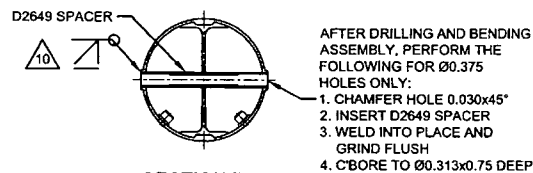
DETAIL E



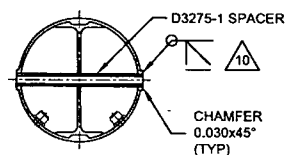
DETAIL G
SCALE 1:5



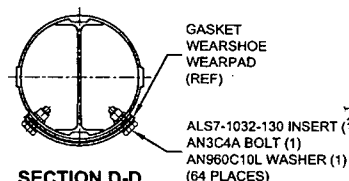
SECTION J-J



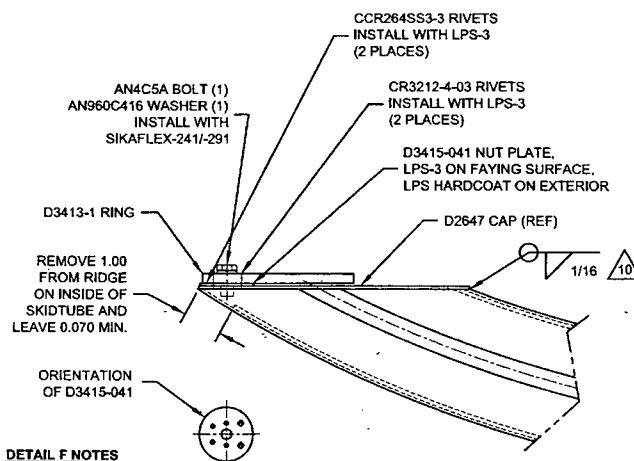
SECTION B-B
FOR Ø0.375 HOLES ONLY
(TYP, 9 PLACES)



SECTION C-C
FOR Ø0.313 HOLES ONLY
(TYP, 6 PLACES)



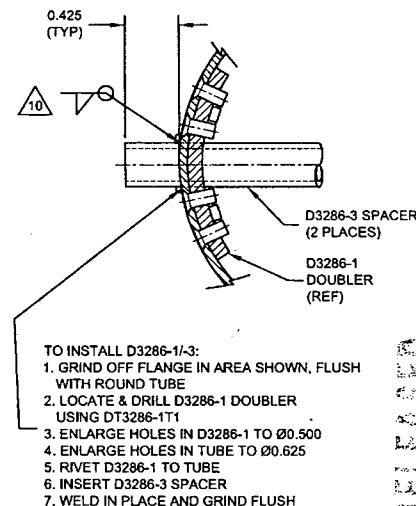
SECTION D-D
FOR WEARSHOES INSTALL ONLY
(TYP, 32 PLACES)



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

DETAIL F: END FINISHING DETAIL



SECTION H-H
NOT TO SCALE

DESIGN	7	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PC	DRAWING NO.	REV. F
MFG. APPR.	PC	D3288	SHEET 2 OF 2
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	SKIDTUBE ASSEMBLY	1:3
DATE	07.11.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: April 25, 2008 12:33 AM
To: 'Peter Hum'
Cc: 'Chris Provencal'
Subject: RE: D206-642-641 float skidtube and D206-642-141 skidtube

There is no reason to c'bore that hole on -641.
 OK to sign off a deviation for existing production and update the drawing for the future.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Thursday, April 24, 2008 9:09 AM
To: David Shepherd
Cc: 'Chris Provencal'
Subject: D206-642-641 float skidtube and D206-642-141 skidtube

David,

Dan Paquette in landing gear noticed an inconsistency between the D206-642-641 float skidtube (D3288-041) and D206-642-141 skidtube (D2650-1):

- a) On D2650-1, the hole immediately forward of the 2 GHW holes that protrude out of the skidtube is NOT C'BORED (see attached)
- b) On D3288-041, the same hole IS C'BORED (see attached)

I did some digging with ChrisP and found out that we have a D206-651 GHW kit that uses the above hole. A D2711 pin goes thru at this location and I think a c'bore would NOT be necessary. Production has been making the D206-642-641 float skidtube WITHOUT the c'bore and it has been shipped to customers.

There is a few D206-642-641 in production, and they are wondering if this hole needs to still be c'bored because that was what they previously have been doing (this problem was only discovered now)

I think we should do the following:

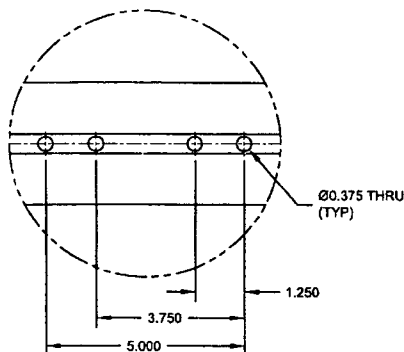
- a) Allow the hole to be NOT C'BORED (i.e. sign a deviation)
- b) Update the drawing to remove the C'BORE

I don't think this will affect anything that has been shipped because the D2711 will still fit and perform as intended.

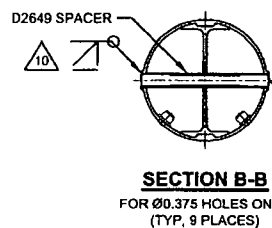
Is there a specific reason why the float skidtube needs the C'bore but not on the std. skidtube? (I think this detail was missed on the drawing updates of the D3288)

What do you think? Have I missed something?

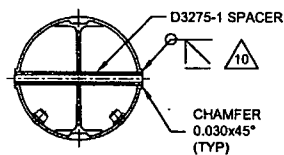
Peter Hum
 Mechanical Designer
 Dart Aerospace Ltd.
 1270 Aberdeen St.
 Hawkesbury, ONT, K6A 1K7
 Tel: (613) 632-5200
 Fax: (613) 632-9311



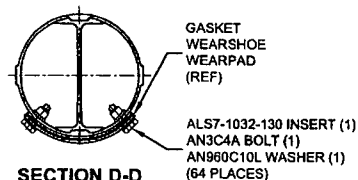
DETAIL A: DRILL DETAIL



SECTION B-B
FOR Ø0.375 HOLES ONLY
(TYP, 9 PLACES)



SECTION C-C
FOR Ø0.313 HOLES ONLY
(TYP, 6 PLACES)

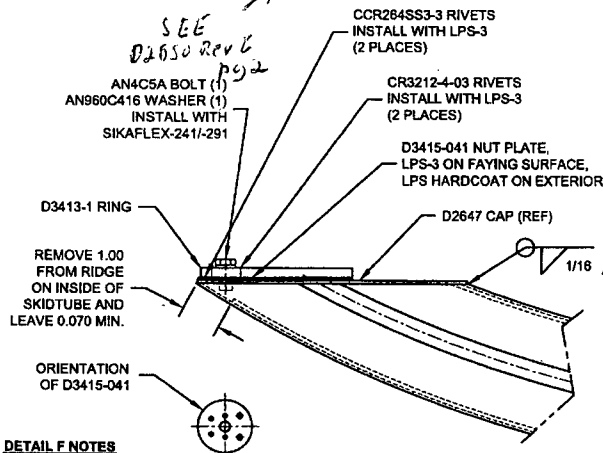


SECTION D-D
FOR WEARSHOES INSTALL ONLY
(TYP, 32 PLACES)

AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

DRILL Ø0.208 THRU PRIOR
TO INSTALLING D2646 CAP
BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

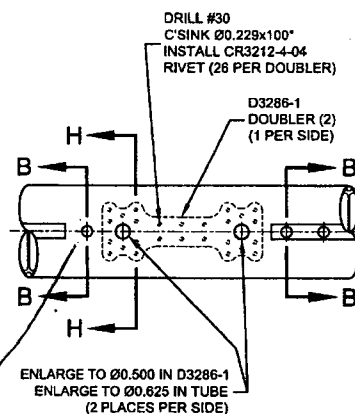
DETAIL E



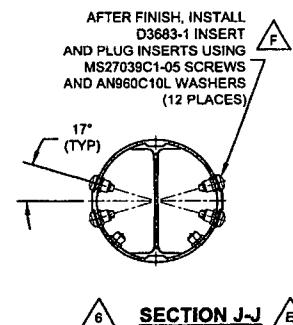
DETAIL F NOTES

- CUT TUBE LEVEL
 - REMOVE RIDGE ON FWD SIDE
 - LOCATE D2647 (TRIM AS NECESSARY)
 - WELD D2647 IN PLACE PER DART QSI 004
 - GRIND FLUSH
 - RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

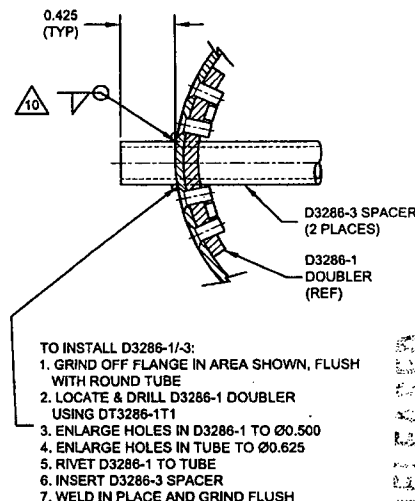
DETAIL F: END FINISHING DETAIL



DETAIL G
SCALE 1:5



SECTION J-J



SECTION H-H
NOT TO SCALE

DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PS	DRAWING NO.	REV. F
MFG. APPR.	PS	D3288	SHEET 2 OF 2
APPROVED	PS	TITLE	SCALE
DE APPR.	PS	SKIDTUBE ASSEMBLY	1:3
DATE	07.11.21	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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